



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

PC250-500A Job Sheet 200887



Part No: PC250-500A

Job Qty: 3 pcs

Part Name: Lock Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/18/19

Job Tracking No:

Due Date: 11/1/19

Created By: Jennifer Renwick

Type: SOLD

Description: Order 19525

Note: DWG PC250-500A REV:1 IPP REV A 18.02.27 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Conventional Lathe - 1	3 pcs	11/1/19	11/1/19	0.00	1.00	Small Fab - 1		11/19/11/20
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5	DAS	
							Small Fab - 6	4	
							Small Fab - 7	9-89	
							Small Fab - 8		
110	QC 2	3 pcs	11/1/19	11/1/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

Container No: S233266



Part: PC250-500A

Job No: 200887

Serial No/Batch: S233266

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 11/20/19

Plex 9/18/19 1:12 PM Dart.Renwick.Jennifer

				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	11/19/11/20
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
120	QC 8	3 pcs	11/1/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
130	External Load - 2 - B4B	3 pcs	11/1/19	0.00 0.60	External Load - 1 - B4B
					External Load - 2 - B4B
					External Load - 3 - B4B
140	QC 5	3 pcs	11/1/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49

https://www.plexonline.com/3b1cc3ff-2a87-4970-bf61-5173a47e53da/Plexus_Control/Report_View/Viewer_2.asp?URL=https://www.plexonline.com/3b1cc3ff... 3/5

				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	23
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
190 QC 21 - FG	3 pcs	11/1/19	0.00 0.00	QC 21 - FG - 21	21
				QC 21 - FG - 70	9-89
				QC 21 - SA - 53	NOV 29 2019

Part Op 100 - 1-Turn PC250-530 to finished OD. Ensure press fit dimensions in PC250-500. 2-Parts must stay together as a Descriptions: matched set. Identify accordingly. 3-Apply LPS-3 to ALL steel parts

110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

130 - 1-Press fit as per drawing. 2-Apply LPS-3 to ALL steel parts

140 - QC5- Inspect part completeness to step on W/O)

150 - -Issue P/O; 45758 -All noncertified parts specifying a finish of Nickel Plating per QQ-N-290, or parts with drawings that are missing a specification Can be Nickel Plated per ASTM B733 Type 4/5, SC0-SC4 or MIL-C-26074 Class 1/2 -Material type; 4140 -Plating thickness must be carried out as specified on the drawing. -Certificate of Conformity is required

160 - (Pac2-Receive & Inspect for Damage & Mat'l Certs.)

170 - (QC6- All purchased or subcontracted products)

180 - (Identify as per dwg & Stock Location:_____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
PC250-500	Lock	3 pcs (1 ea)	100-Conventional Lathe - 1	S221889
PC250-530	Shaft	3 pcs (1 ea)	100-Conventional Lathe - 1	S229168

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Conventional Lathe - 1	PC250-500	3	0	0
	PC250-530	3	0	0
Part Specifications				
Specifications could not be found.				

Plex 9/18/19 1:12 PM Dart.Renwick.Jennifer

GA 209



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QSI042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Other/Details: _____

Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐

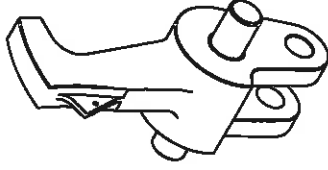
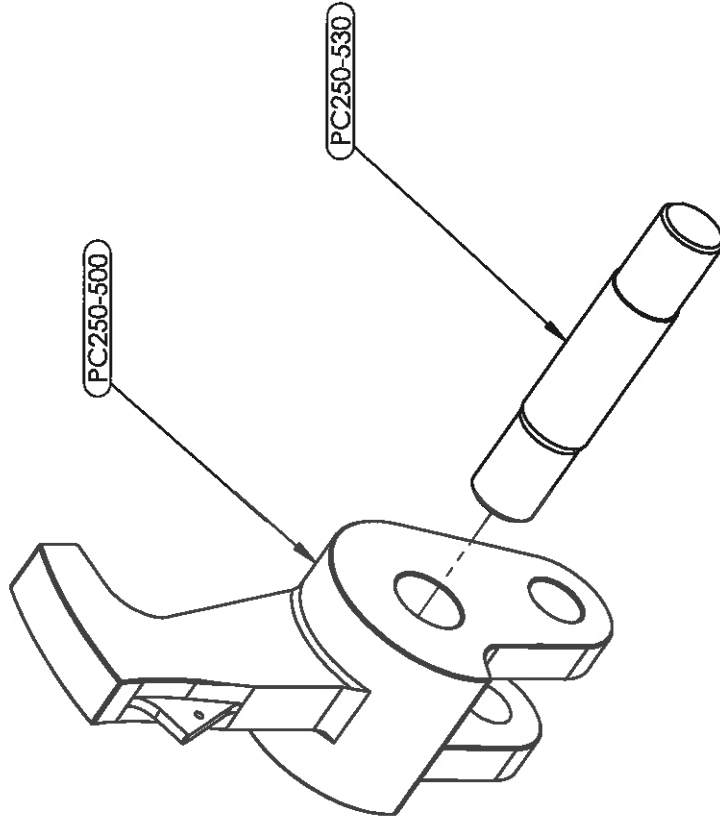
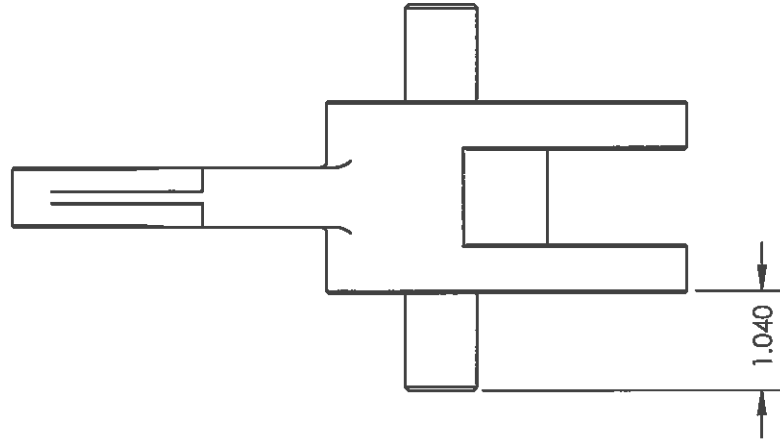
Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐

Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐

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REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	14-0128	AS DRAWN BY APICAL CH'D TITLE BLOCK WAS RED BARN'S DART. CORRECTED TITLE & DWG No ON ALL SHEETS. PC250-500 ADDED MACHINE ENGRAVE NOTE. PC250-530 ADDED BAG & LABEL NOTE.	6/14/2013	CFS	
			8/14/2014	DPD	RW



NOTE: NICKEL PLATE .0004 - .0006, BAKE AFTER PLATING.



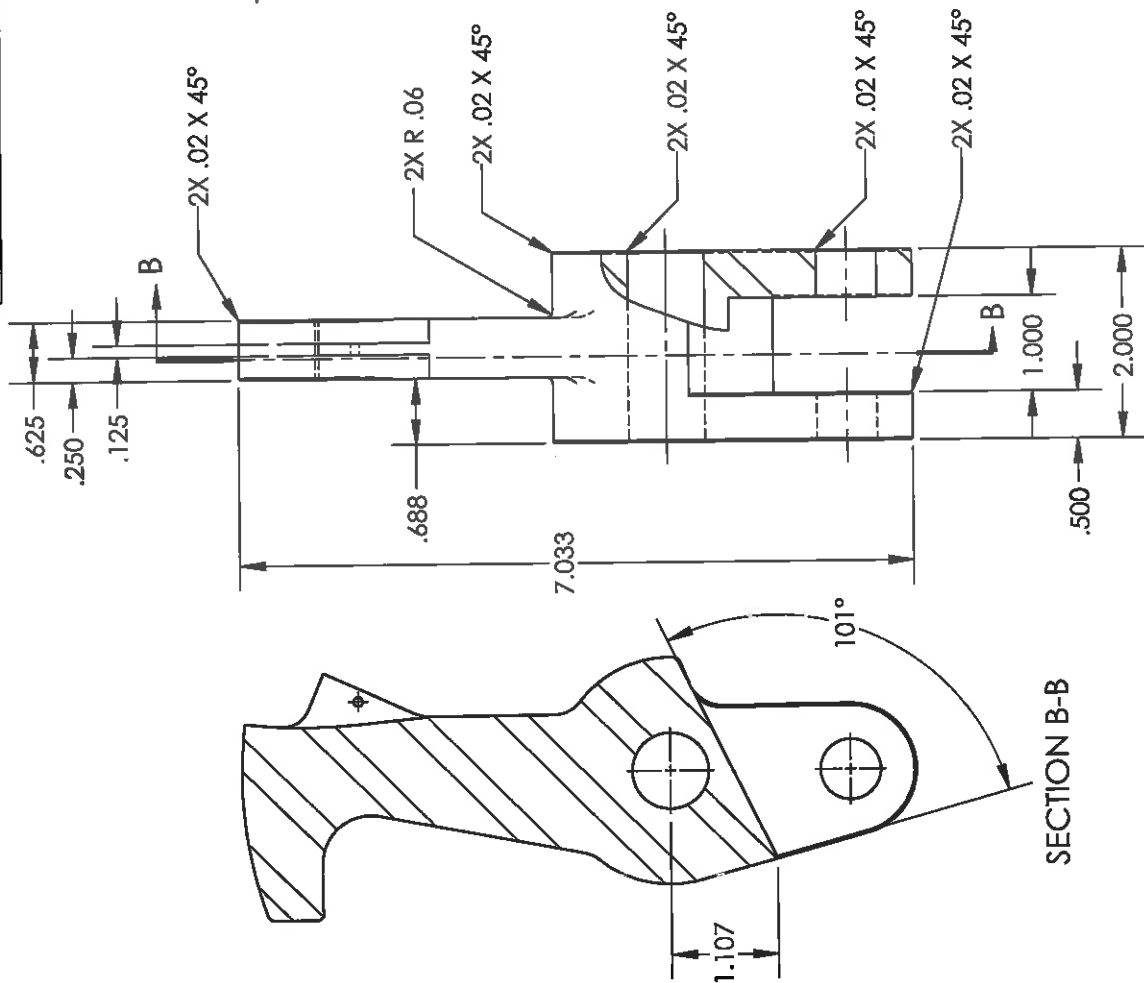
LOCK ASSEMBLY

DWG NO.	PC250-500A	REV	1
MAT'L	APICAL	DRAWN BY:	APICAL
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED	DATE	6/14/2013
.XXX ± .005	REVIEWED	DATE	8/14/2014
.XX ± .01	FINISH	DATE	8/14/2014
.X ± .1	FINISH	DATE	8/14/2014
1. BREAK ALL SHARP EDGES .015 x 45°	FINISH	DATE	8/14/2014
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	FINISH	DATE	8/14/2014
SCALE	1:2	DATE	2/10/2010
SHEET	1 OF 3	DATE	2/10/2010

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			PC250-500	1	LOCK	4140	2-1/8 X 2-1/2 X 7-1/8	2
			PC250-530	1	SHAFT	4140	Ø7/8 X 4-1/8	3

REVISIONS

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	14-0128	PC250-500 ADDED MACHINE ENGRAVE NOTE.	8/14/2014	DPD	RW



NOTE:

MACHINE ENGRAVE BATCH NUMBER.

**TITLE**

LOCK ASSEMBLY

DWG NO.

PC250-500A

1

MATL 4140

APICAL

UNLESS OTHERWISE SPECIFIED

D Weil

XXX + .005 FRACTIONS + 110
DIMENSIONS ARE IN INCHES

HRC 42-44

ANGLES $\pm 5^\circ$

FINISH SEE SHEET 1, NOTE 1

X I.1
4 BREAK ALL SHARP EDGES 015 x 45"

SPEC

1. BREAK ALL OTHERS EPOLES: 0.15 X 40
OR .015R

USED ON MODEL

2. DIMENSIONAL LIMITS APPLY AFTER PLATING

1.2

DATE _____

5/20/2004

SHEET 2 OF 3

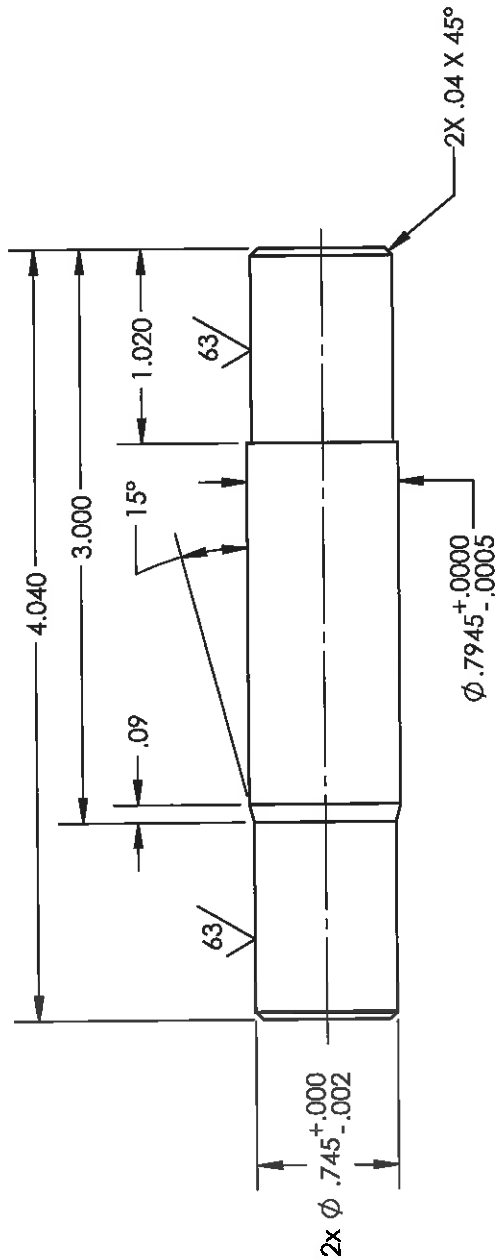
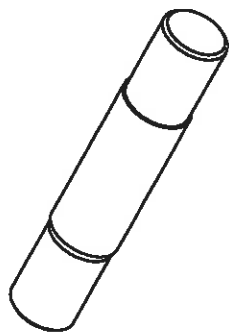
PC250-500

LOCK

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REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	14-0128	PC250-530 ADDED BAG & LABEL NOTE.	8/14/2014	DPD	RW



NOTE:
BAG & LABEL WITH BATCH NUMBER.



LOCK ASSEMBLY

TITLE

DWG NO.

PC250-500A

REV

1

MAT'L 4140	DRAWN BY: APICAL
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Wed</i>
.XXX ± .005	HEAT TREAT HRC 44-46
.XX ± .01	FINISH SEE SHEET 1, NOTE 1
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 2/10/2010
	SHEET 3 OF 3

PC250-530

SHAFT



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB045158**



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045158

PO Date: 11/20/19

Due Date: 11/28/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-11-25

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
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Dart Aerospace Ltd.
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PURCHASE ORDER **POHB045158**



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	OH201652	C60-OH	OM&OOPM-C60 Rev 3	C-Series Remote Hook 6,000 lbs Lift Capacity -Issue P/O - parts to be stripped first -All noncertified parts specifying a finish of Nickel Plating per QQ-N-290, or parts with drawings that are missing a specification Can be Nickel Plated per ASTM B733 Type 4/5, SC0-SC4 or MIL-C-26074 Class 1/2 -Material type; -Heat treat must be carried out to specified hardness if noted on the drawing. -Plating thickness must be carried out as specified on the drawing. -Certificate of Conformity is required	Firmed	-	11/28/19	1 pcs	0 pcs	1 pcs	\$154.2433/pcs	\$154.24

X1

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DF

Line Item Note: 1 kit = 5 pcs



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PURCHASE ORDER **POHB045158**



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	200691	PC250-700	PC250-700 Rev 2	Lever Arm -Issue P/O; -All noncertified parts specifying a finish of Nickel Plating per QQ-N-290, or parts with drawings that are missing a specification Can be Nickel Plated per ASTM B733 Type 4/5, SC0-SC4 or MIL-C-26074 Class 1/2 -Material type; -Heat treat must be carried out to specified hardness if noted on the drawing. -Plating thickness must be carried out as specified on the drawing. -Certificate of Conformity is required	Firmed	-	11/28/19	4 pcs	0 pcs	4 pcs	\$11.9333/pcs	\$47.73

X4

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DP



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PURCHASE ORDER **POHB045158**



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	201077	PC250-610	PC250-610 Rev A	Pin (Outside Processing - Nickel Plate) -Issue P/O; -All noncertified parts specifying a finish of Nickel Plating per QQ-N-290, or parts with drawings that are missing a specification Can be Nickel Plated per ASTM B733 Type 4/5, SC0-SC4 or MIL-C-26074 Class 1/2 -Material type; 4140 -Heat treat must be carried out to specified hardness if noted on the drawing. -Plating thickness must be carried out as specified on the drawing. -Certificate of Conformity is required	Firmed	-	11/28/19	20 pcs	0 pcs	20 pcs	\$4.2233/pcs	\$84.47



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PURCHASE ORDER

POHB045158



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	R202026	C3-4-4KA	C3-4-4A/C3-4-4KA Rev 10	Keeperless Load Beam Assembly - C3 Hook (Outside Processing - Nickel Plate) --Issue P/O; -All noncertified parts specifying a finish of Nickel Plating per QQ-N-290, or parts with drawings that are missing a specification Can be Nickel Plated per ASTM B733 Type 4/5, SC0-SC4 or MIL-C-26074 Class 1/2 -Material type; 4140 -Heat treat must be carried out to specified hardness if noted on the drawing. -Plating thickness must be carried out as specified on the drawing. -Certificate of Conformity is required	Firmed	-	11/28/19	8 pcs	0 pcs	8 pcs	\$26.7833/pcs	\$214.27

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PURCHASE ORDER

POHB045158



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	200887	PC250-500A	PC250-500A Rev 1	Lock Assembly -Issue P/O; -All noncertified parts specifying a finish of Nickel Plating per QQ-N-290, or parts with drawings that are missing a specification Can be Nickel Plated per ASTM B733 Type 4/5, SC0-SC4 or MIL-C-26074 Class 1/2 -Material type; 4140 -Plating thickness must be carried out as specified on the drawing. -Certificate of Conformity is required	Firmed	-	11/28/19	3 pcs	0 pcs	3 pcs	\$25.0133/pcs	\$75.04
Grand Total:												\$575.75

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Guerin

Plex 11/25/19 8:36 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(024313-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

024313 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date	Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
26-Nov-2019	Jigar Patel		POHB045158					
#ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/ Scrap	À venir/ Back Order
1	C60-OH Rev.3	OM&OOPM-C60 E-NIC STEEL 500 [E-NICKEL STEEL 500] AS PER QQ-N-290 OR AS PER ASTM B733 TPYE - 4 / 5, SCD - SC4 OR MIL-C-26074 CLASS 1/2 0.0009 " - 0.0011 " (THICKNESS FOR THE HOOK) 0.0004 " - 0.0006 " (THICKNESS FOR THE REST OF THE PARTS) BAKE AFTER	E-NICKEL-500 LOT	1	1	0	0	0
2	PC250-700 Rev.2	PC250-700 E-NIC STEEL 500 [E-NICKEL STEEL 500] AS PER QQ-N-290 OR AS PER ASTM B733 TPYE - 4 / 5, SCD - SC4 OR MIL-C-26074 CLASS 1/2 0.0004 " - 0.0006 " THICKNESS BAKE AFTER	E-NICKEL-500 CH	4	4	0	0	0
4	C3-4-4KA Rev.	C3-4-4A/C3-4-4KA 10 E-NIC STEEL 500 [E-NICKEL STEEL 500] AS PER QQ-N-290 OR AS PER ASTM B733 TPYE - 4 / 5, SCD - SC4 OR MIL-C-26074 CLASS 1/2 0.0009 " - 0.0011 " THICKNESS BAKE AFTER	E-NICKEL-500 CH	8	8	0	0	0
5	PC250-500A Rev.	PC250-500A 1 E-NIC STEEL 500 [E-NICKEL STEEL 500] AS PER QQ-N-290 OR AS PER ASTM B733 TPYE - 4 / 5, SCD - SC4 OR MIL-C-26074 CLASS 1/2 0.0004 " - 0.0006 " THICKNESS BAKE AFTER	E-NICKEL-500 CH	3	3	0	0	0

Notes Additionnelles / Additional Notes

RECEIVED

NOV 27 2019

DART AEROSPACE LTD.

Epaisseur Réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

RECEIVED

NOV 27 2019

DART AEROSPACE LTD.

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.